

Monday, 4/24/2006 10:22:26 AM  
Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FLOAT STEP ASSEMBLY (206/407)		
Job Number	: 26753A		Part Number	: D2842042		
Estimate Number	: 11775		Drawing Number	: D2842 REV B		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 4/24/2006	S.O. No. : N/A	Drawing Revision	: B		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 5/10/2006		
Previous Run	: N/A		Qty:	2	Um:	Each
Written By	: See Comment Below					
Checked & Approved By	: OA 06.04.24					
Comment	: Est Rev:D As Per Ecn 766 06-01-06 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2622120C	Extrusion	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Qty Part # Description Batch: 1 D2622-120C Extrusion <u>824563</u>	
		Check Material for any Dents or Defects	
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
		Comment: LARGE FABRICATION RESOURCE 1 1-Cut D2842-1 using D2622 extrusion as per Dwg D2842 2-Drill D2842-1 using Jig DT8272 as per Dwg D2842 3-Deburr and bevel ends for welding	
3.0	D2734	206 Step Endplate	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) 206 Step Endplate Pick: Qty Part Number Description Batch 2 D2734 End Cap <u>324402</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: GU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Job Number: 26753A

Part Number: D2842042

Number:



Seq. #:

Machine Or Operation:

Description :

4.0

D2776

Step.Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Step Lug

Pick:

Qty Part Number Description Batch

2 D2776Lug 325430

P.T.O

SL 06-05-03

2

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld one end cap and (2) lugs using Jig DT followed by DT as per Dwg D2842  
A/R AL Rod Batch: M18838

SL 06-05-04 2

2-Grind end cap weld flush

FF 06-05-04 2

2

6.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

Handwritten: 11/06/05/08 (2)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

DL 06/05/08 (2)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PD 06-05-09

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Remove alodine prior to welding.

Weld end cap as per Dwg D2842.

A/R AL Rod Batch: M15689

SL 06-05-09 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod.Mgr	Approval QC Inspector
06.05.03	4.0	Pick Qty 2 D3459-3 Description lug B 25430	PE	06.05.03	2	<i>PD</i>	<i>✓</i>
	4.6	Pick Qty 2 D3459-1 Description lug B 25429	PE	06.05.03	2	<i>GRW</i>	<i>✓</i>

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  DQA: *✓* Date: *06/06/05*  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/24/2006 10:22:26 AM  
User: Kim Johnston

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Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Job Number: 26753A

Part Number: D2842042

Job Number:



Seq. #: Machine Or Operation: Description :

2-Grind end cap weld flush.

RE. 06.05.09

10.0 QC5/9 WELD INSPECTION



WELD INSPECTION

Job 060509



Comment: WELD INSPECTION

DD 06.05.09

11.0 POWDER COATING POWDER COATING



POWDER COATING



Comment: POWDER COATING

Touch up Alodine end cap and Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06.05.09

12.0 NAS1329C3KB130 insert



insert



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

Insert

Pick:

Qty	Part Number	Description	Batch
3	NAS1329C3KB130	Insert	M100034

13.0 MS27039C107 screw



screw



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
3	MS27039C1-07	Screw	M19522

14.0 NAS1515H3L WASHER



WASHER



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
3	NAS1515H3L	WASHER	M19185

15.0 AN960C10L washer



washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
3	AN960C10L	WASHER	M18822

DL 06.05.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/06/05  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number:



Seq. #: Machine Or Operation:

Description :

16.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: LARGE FABRICATION RESOURCE 1

1-Install inserts as per Dwg D2842

DC : 06/05/11

(2)

2-Wing Walk as per Dwg D2842 and QSI 005 4.1

Batch: M100652

a-r 06-05-10

(2)

17.0 QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

18.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

1/2 06/05/15

06/05/15 (2)

19.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Stocked 05/05 (2)

Job Completion



06-06-05

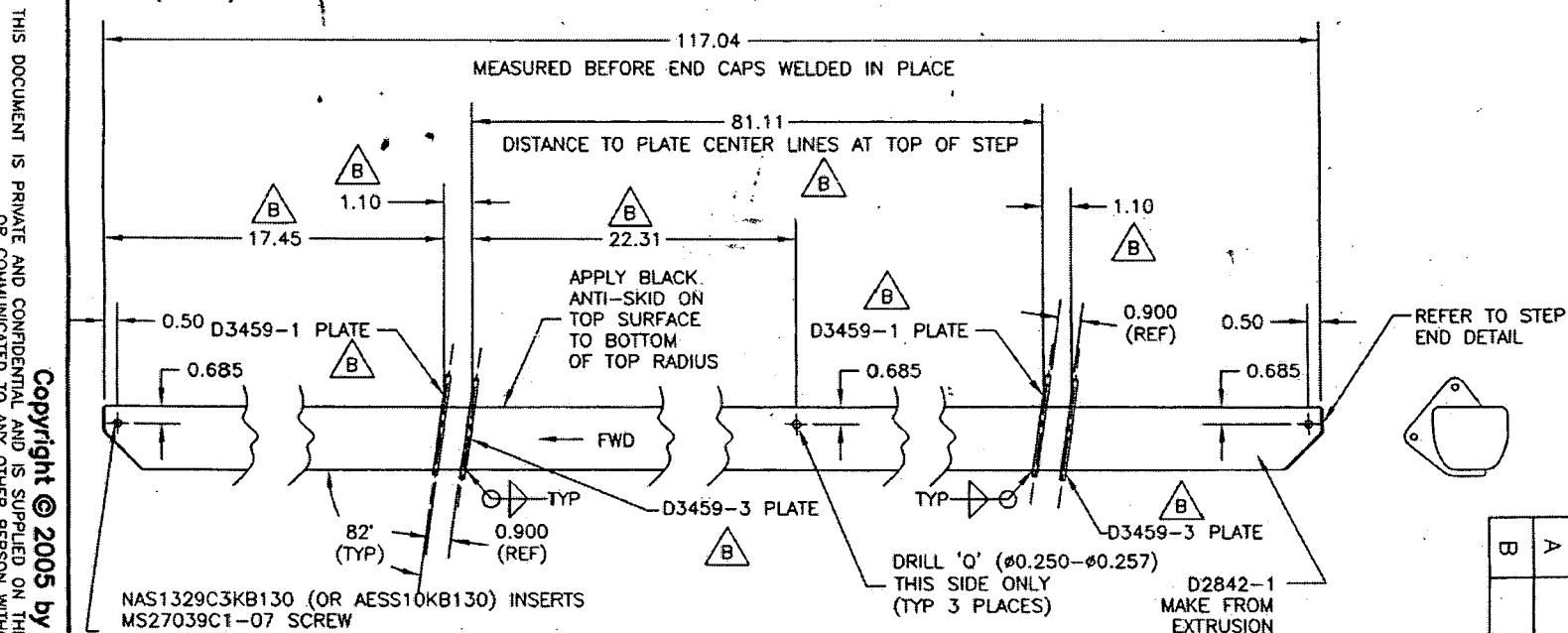
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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**DART**

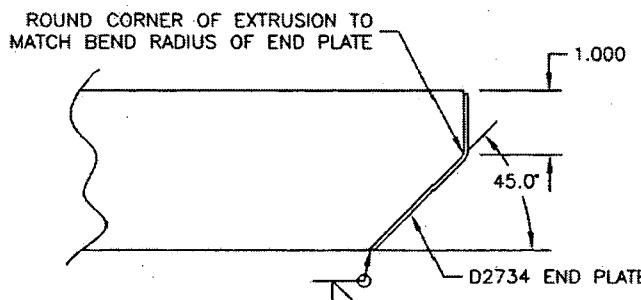


NAS1329C3KB130 (OR AESS10KB130) INSERTS  
MS27039C1-07 SCREW  
NAS1515H3L WASHER  
AN960C10L WASHER  
(TYP 3 PLACES)

D2842-041 LH STEP ASSEMBLY (SHOWN)  
D2842-042 RH STEP ASSEMBLY (OPPOSITE)

**D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST**

QTY	QTY	PART NUMBER	DESCRIPTION
041	042	D2842-041	LH STEP ASSEMBLY / RH STEP ASSEMBLY
X	X	D2842-042	
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER



TYPICAL STEP END DETAIL  
NOT TO SCALE

**D2842-041/-042 FLOAT STEP ASSEMBLY**

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
5-11-14  
DART

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26753A

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DESIGN KE	DRAWN BY PH	DART AEROSPACE USA, INC.	
CHECKED	APPROVED	DRAWING NO.	REV. B
05.09.23	✓	D2842	
A	✓	98.10.13	PORT HADLOCK, WA SHEET 1 OF 1
B	✓	05.09.23	SCALE NTS RE-DESIGN, ADD D3459-1/-3